

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021503**Date Inspected:** 19-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA.**CWI Name:** Ruben Dominguez**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Travelers**Summary of Items Observed:**

This Quality Assurance Inspector Sean Vance arrived on site at Westmont Industries (WMI) in Santa Fe Springs, CA, to randomly observe the in process welding, QC inspection and non-destructive testing of the Travelers.

Upon the arrival of the QA Inspector, the following observations were made:

Traveler Test Rack

This QA Inspector randomly observed WMI production personnel performing fitting, welding and cutting activities on various assemblies for the Traveler Test Rack.

E2/E3-EB Traveler

This QA Inspector observed WMI production welder Mr. Juan Jimenez (WID # 3059) continuing to perform Flux Core Arc Welding (FCAW) activities on the E2/E3-EB North side section. This QA Inspector observed Mr. Jimenez performing the FCAW in all positions on plate and tube steel material, randomly throughout the shift.

This QA Inspector observed WMI production personnel Mr. Cesar Canales, continuing to perform fitting activities on the E2/E3-EB, North and South side sections. In regards to the fitting activities, this QA Inspector observed Mr. Canales utilizing numerous come-a-longs to perform the activities. This QA Inspector observed that Mr. Canales had previously performed dimensional layout on the bay floor and appeared to be utilizing the come-a-long to align the above mentioned sections. This QA Inspector observed that the dimensional layout lines on the floor, appeared to be square.

SAS-WB Traveler

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This QA Inspector observed WMI production welder Mr. Jesus Rayas (WID # 3197) performing Flux Core Arc Welding (FCAW) activities on the SAS-WB platform balcony, assembly 14 A143. This QA Inspector observed Mr. Rayas performing the FCAW in all positions on plate and tube steel material, randomly throughout the shift. Additionally, this QA Inspector observed WMI production welder Mr. Juan Jimenez (WID # 3059) continuing to perform Flux Core Arc Welding (FCAW) activities on the above mentioned assembly. This QA Inspector observed Mr. Jimenez performing the FCAW in all positions on plate and tube steel material randomly throughout the shift.

SAS-EB Traveler

This QA Inspector observed WMI production welder Mr. Charles Newton (WID # 3200) continuing to perform Flux Core Arc Welding (FCAW) activities, on the SAS-EB Fixed Stairs and Lower Truss assemblies. This QA Inspector noted that the FCAW was being performed on the tube steel connection weld joints for the mentioned assemblies. This QA Inspector noted that the sections had been previously cut out and the FCAW was being performed on the newly fabricated section (RFI-002361R00). This QA Inspector observed Mr. Newton performing the FCAW in all positions, throughout the shift. Additionally, this QA Inspector observed WMI production welder Mr. Eutimo Lopez (WID # 3035) performing Flux Core Arc Welding (FCAW) activities on the above mentioned assembly. This QA Inspector observed Mr. Lopez performing the FCAW in all positions, throughout the shift.

This QA Inspector randomly observed that Smith Emery QC Inspector Mr. Ruben Dominguez was present, during the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Dominguez verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

This QA Inspector observed that the activities mentioned above, appeared to be in compliance with the contract requirements and this QA Inspector observed no non-conforming issues, on this date.

This QA Inspector continued to perform courtesy preliminary reviews of WMI Weekly Weld Reports, prior to WMI formally submitting to Caltrans for review.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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| Inspected By: | Vance,Sean | Quality Assurance Inspector |
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| Reviewed By: | Edmondson,Fred | QA Reviewer |
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